



NO. 24 (363)

UNCONTROLLED SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

ENGINEERING

RETURN TO

SHOP COPY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT BLADE FOLD ASSY WELDMENT
Job Number: 41363		Part Number: PB674300109
Job Number:		
Seq. #:	Machine Or Operation:	Description :
20.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		
		 08/10/23 JF
		 JF 08-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT BLADE FOLD ASSY WELDMENT
Job Number: 41363		Part Number: PB674300109
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
13.0	D344013	Bracket  4
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) Bracket batch:- B41452	 <i>CPL 08-10-20</i>
14.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
	Comment: LARGE FABRICATION RESOURCE 1 1- assemble parts on jig DT8814 and weld as per dwg PB67-43001 ** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***	<i>SP 08.10.20</i> <i>CPL 08-10-20</i>
15.0	QC9	VISUAL WELDING INSPECTION 
	Comment: VISUAL WELDING INSPECTION	<i>108/10/21 (2)</i>
16.0	QC5	INSPECT WORK TO CURRENT STEP 
	Comment: INSPECT WORK TO CURRENT STEP	<i>S 08/10/21 (2)</i>
17.0	POWDER COATING	POWDER COATING  <i>M106316</i>  (2)
	Comment: POWDER COATING ***in detail D, mask in between -311 prior to paint*** ***mask 1.750" on the end of -243 prior to paint*** ***mask inside of D3440-9 prior to paint***	
	Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 START TIME: <i>1:00</i> OVEN TEMPERATURE: <i>320</i> °F FINISH TIME: <i>1:30</i>	<i>MJ 08/10/21</i>
18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>FJ 08/10/21 (2)</i>
19.0	PACKAGING 1	PACKAGING RESOURCE #1 
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>CPL 08-10-21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: AFT BLADE FOLD ASSY WELDMENT
Job Number: 41363	Part Number: PB674300109
Job Number:	
Seq. #:	Machine Or Operation:
6.0	PB6743001235 Outer Tube  Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Outer Tube batch: <u>341490</u>
7.0	PB6743001229 Outer Tube  Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Outer Tube batch: <u>341489</u>
8.0	PB6743001213 Flanged Hook  Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Flanged Hook batch: <u>B 140211</u> 4 mx. B 414887
9.0	PB6743001311 Restraint  Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Restraint batch: <u>341211</u>
10.0	PB6743001277 Contoured Hinge Arm  Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Contoured Hinge Arm batch: <u>B 41499</u>
11.0	PB6743001243 Handle Arm Extension  Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Handle Arm Extension batch: <u>B 040211</u> 2 mx. B 40444
12.0	D34409 Tube Detent Clip Base  Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Tube Detent Clip Base batch: <u>B 41205</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT BLADE FOLD ASSY WELDMENT	
Job Number	: 41363		Part Number	: PB674300109	
Estimate Number	: 13503		Drawing Number	: B6743001 P.6	
P.O. Number	:		Project Number	: N/A	
This Issue	: 18/08/2008 S.O. No. :		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : LARGE FAB ASSY		Due Date	: 18/09/2008 Qty: 18	
Previous Run	: 40772		Um:	Each	
Written By	:				
Checked & Approved By	: JL008.8.18				
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001211	Square Tubing	132
			Barcode
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 48.0000 Each(s)	P008.10.20
		Square Tubing batch: 341487	
2.0	PB6743001209	Square Tubing	8
			Barcode
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	P008.10.20
		Square Tubing batch: 100595 x 2m	
3.0	PB6743001201	Square Tubing	84
			Barcode
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)	P008.10.20
		Square Tubing batch: 1241572	
4.0	PB6743001203	Square Tube	142
			Barcode
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	P008.10.20
		Square Tube batch: 405914 x 41769 8	
5.0	PB6743001239	Square Tube	142
			Barcode
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	P008.10.20
		Square Tube batch: 1241909	